

ABSTRACT OF THE DISCLOSURE

A discharge pulse number generated between a wire electrode and a workpiece is counted every predetermined time. A ratio P_x/P_s of this counted value P_x to the reference pulse number P_s will be determined to control an amount of coolant in response to this ratio P_x/P_s . Also, in response to this ratio P_x/P_s , an amount of movement within predetermined time is controlled. Further, through the ratio P_x/P_s and the like, quiescent time to be controlled by the detection voltage generator is controlled. Thereby, surplus supply of energy is prevented, the machining speed and machining precision is improved and any disconnection of the wire electrode is avoided.